



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 167787



Part No: D350-591-311

Job Qty: 1 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/6/17

Job Tracking No:

Due Date: 11/17/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Airbus Helicopters - Marignane (CEURO24)

Aéroport International De Marseille Cedex Marignane Marseille, 13725 France ph:+33 4 42 85 85 85 fx:+33 4 42 85 83 00.

Ship Via:

~~AIRBUS~~ CHG001

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	10 Ea		11/15/17	0.00	0.00	Start Up Large Fab2		SL 11/29/17
110	Large Fab	10 pcs		11/16/17	0.00	9.91	Large Fab 2		SL 11/29/17
120	QC	10 pcs		11/16/17	0.00	0.00	QC9		PD 11.12.34
130	QC	10 pcs		11/16/17	0.00	0.00	QC5		PD 11.12.34
140	HandFinish	10 pcs		11/16/17	0.00	1.84	HandFinish1		2017-12-06
150	QC	10 pcs		11/16/17	0.00	0.00	QC7		38
180	Large Fab	10 pcs		11/16/17	0.00	9.91	Large Fab 2		SL 11/12/12
190	QC	10 pcs		11/16/17	0.00	0.00	QC10		38
200	QC	10 pcs		11/16/17	0.00	0.00	QC5		38
210	HandFinish	10 pcs		11/16/17	0.00	1.84	HandFinish1		2017-12-13
220	Powdercoat	10 pcs		11/16/17	0.00	2.90	Powdercoat1		BR 17-12-14
230	HandFinish	10 pcs		11/17/17	0.00	1.84	HandFinish3		BRB 17/12/18
240	QC	10 pcs		11/17/17	0.00	0.00	QC3		38
250	Packaging	10 pcs		11/17/17	0.00	0.00	Packaging1		SM 18 JAN 18 2018
260	QC	10 pcs		11/17/17	0.00	0.00	QC4		SM
265	DC	10 pcs		11/17/17	0.00	0.00	DC		AT
270	Packaging	10 pcs		11/17/17	0.00	0.00	Packaging3		SM
280	QC21-FG	10 Ea		11/17/17	0.00	0.00	QC21		JAN 22 2016

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 11:15 OVEN TEMPERATURE: 320° FINISH TIME: 11:45

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

wing walk M138711

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D3067-1 (5012005) (165725)	10	38	0	0
	D3219-1 (5012005) (165725)	20	57	0	0
	D3272-1 (5008818)	10	3	0	0
	D3065-041 (5016987)	10	11	0	0
180-Large Fab					

DQA

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____ NCR No. _____		Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐			
		Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐			
		Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			
		Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐				
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

250-Packaging

D3066-1	20	28	0	0
D3067-1	10	38	0	0
MS20600-AD4W4	160	686	0	0
-AN3-35A	20	22	0	0
-AN4-13A	80	477	0	0
-AN5-36A	20	102	0	0
-D2230-3	40	111	0	0
-D2618	20	139	0	0
-D2856-400-720	20	125	0	0
-D3235-1	20	13	0	0
-D3278-041	10	27	0	0
-MS21042L3	20	1,431	0	0
-MS21042L4	80	1,670	0	0
-MS21042L5	20	427	0	0
-NAS1149D0363J	40	594	0	0
-NAS1149D0463J	160	1,482	0	0
-NAS1149D0563J	40	1,394	0	0
DSI 9410-011	2	504723	5034209	

Part Specifications

Specifications could not be found.

Plex 11/6/17 4:03 PM dart.poulin.mario

DART
AEROSPACE
S015309

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com



Heli - Access - Step LH - High Gear, Long Step, Aerazur
Float Compatible

PART NO: D350 - 591 - 311

Revision:

Operation: Large Fab

Change No:

Mfg Date: 11/29/17

Job No: 167787

DQA

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>0250591311</u> Part No. <u>167782</u> NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☒</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Large Fab ☐	Composite ☐	Supplier ☐																																																																							
Date: <u>17-12-20</u>		Step #: <u>240</u>		QTY Effective: <u>2</u>		MRB (QS1042) Approval																																																																			
Description Work Order Deviation				Disposition		<u>PD 17.12.20</u>																																																																			
Defect found in powder coat yellow line came through paint on ply 2 step.				split work order for qty 2 scuff entire step and re powder coat and ID step at CHG 002 (not to be sold for airbus) <u>M138467.</u> <u>RECOAT.</u> <u>START: 4:45.</u> <u>OUT: 3:00</u> <u>FINISH: 5:15.</u> <u>18-01-16.</u>		Completed By <u>BEB 18/01/17</u>																																																																			
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Change Record

PAGE 1 OF 1

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]

REFERENCE ONLY

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Hel-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Hel-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Hel-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Hel-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Hel-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Hel-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: AN5-36A Revision: Bolt														
100	Receive Ea	S033056	167787	4 Ea	0	S024840	Packaging1		Stock	1/17/2018	Issue Container			
Operation Totals:		1		4	0									
Part Totals:		1		4	0									
Part Number: D2856-400-720 Revision: Abrasion Strip 4" X 7.20"														
130	QC21-SA	S033047	167787	1 Ea	0	S009400	Packaging1	Bin	Stock	1/17/2018	Issue Container			
Operation Totals:		1		1	0									
Part Totals:		1		1	0									
Part Number: D350-591-311 Revision: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible														
280	QC21-FG	S015309	167787	2 Ea	0	S015309	FG084	Bin	Stock	11/29/2017	Issue Container			
Operation Totals:		1		2	0									
Part Totals:		1		2	0									
Part Number: DSI 9410-011 Revision: Amends Installation Of D350-591-311/-312 Steps														
140	QC21-FG	S034209	167787	2 Ea	0	S019728	ST123		Stock	1/22/2018	Issue Container			CHG002
Operation Totals:		1		2	0									
Part Totals:		1		2	0									
Part Number: MS21042L5 Revision: Nut														
100	Receive Ea	S033040	167787	2 Ea	0	s016880	Packaging1		Stock	1/17/2018	Issue Container			
Operation Totals:		1		2	0									
Part Totals:		1		2	0									
Totals:		5		11	0									

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																														
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